

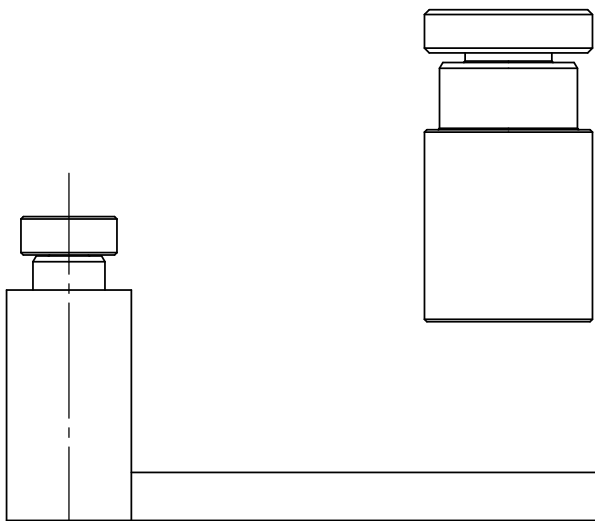
ITEM #	QTY.	PART #	PART TITLE
-3	1	RB T101896-3	BAR WELDED ASSY
-5	1	RB T101896-5	BASE
-11	2	RB T101896-11	SPINDLE NUT
-13	1	RB T101896-13	GRIP PIN
-15	2	RB T101896-15	SPINDLE PIN
-17	1	RB T101896-17	GRIP NUT
18	4	McMaster#91253A544 OR EQUIV.	COUNTERSUNK SCREW, 1/4-20 X 1-1/4 LG

D

C

B

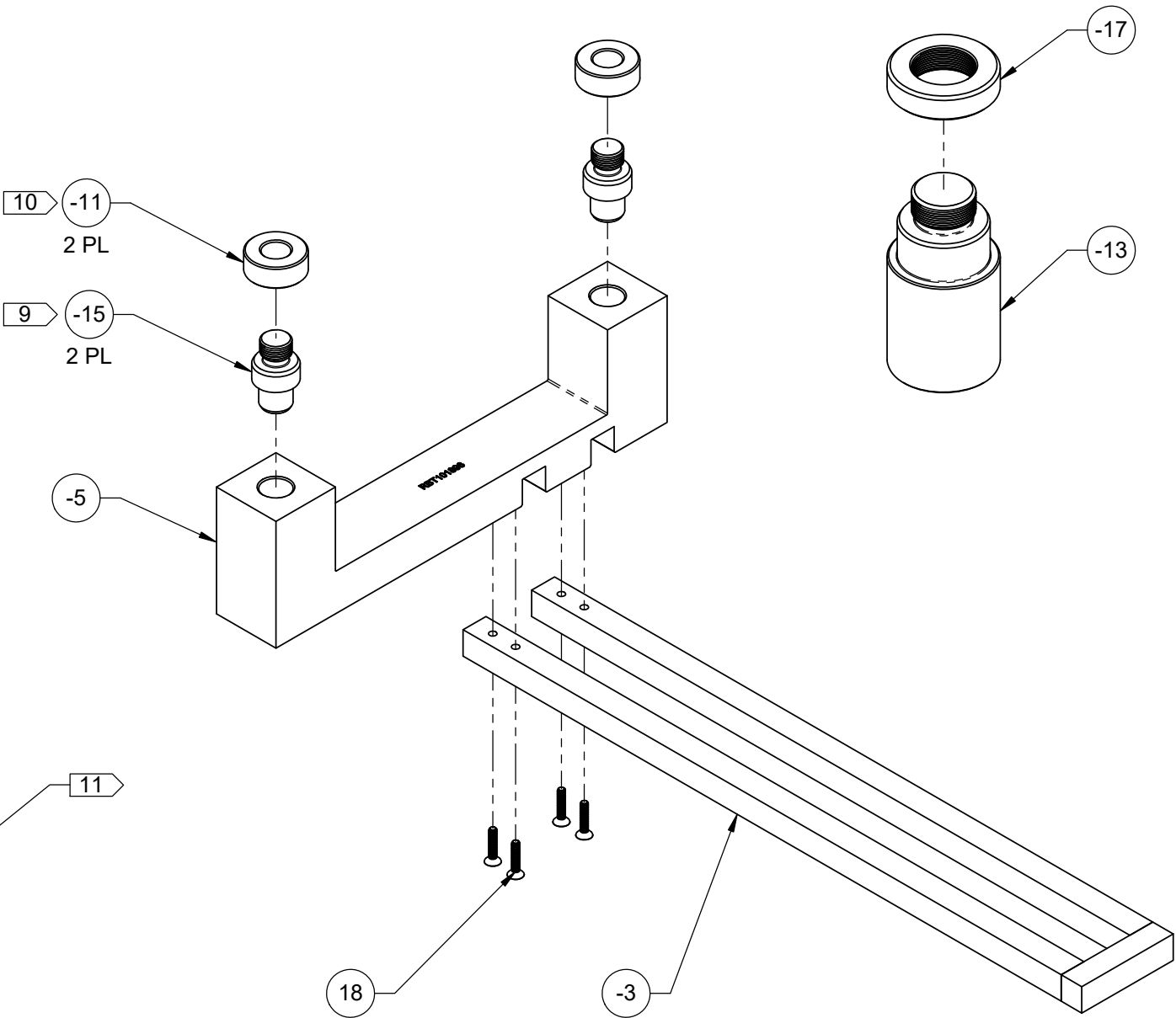
A



25.752
25.748

RB T101896 M/R GRIP SPACING TOOL

- NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) APPLY LOCTITE 262 / 263 ON THE THREADS OF ITEM 18 THEN ASSEMBLE AS SHOWN AND TORQUE TO 40-50 IN-LBS
9) APPLY CLEAR MULTIPURPOSE LOCTITE ON MATING SURFACES THEN PRESS FIT ITEM -15 WITH ITEM -5 AND REMOVES EXCESS LOCTITE
10) INSTALL HAND TIGHT
11) REMOVE MATERIAL FROM THIS FACE IF NECESSARY TO ACHIEVE REQUIRED DIMENSION, SURFACE FINISH OF32 RA MICROINCH (N6) OR BETTER IS REQUIRED



D

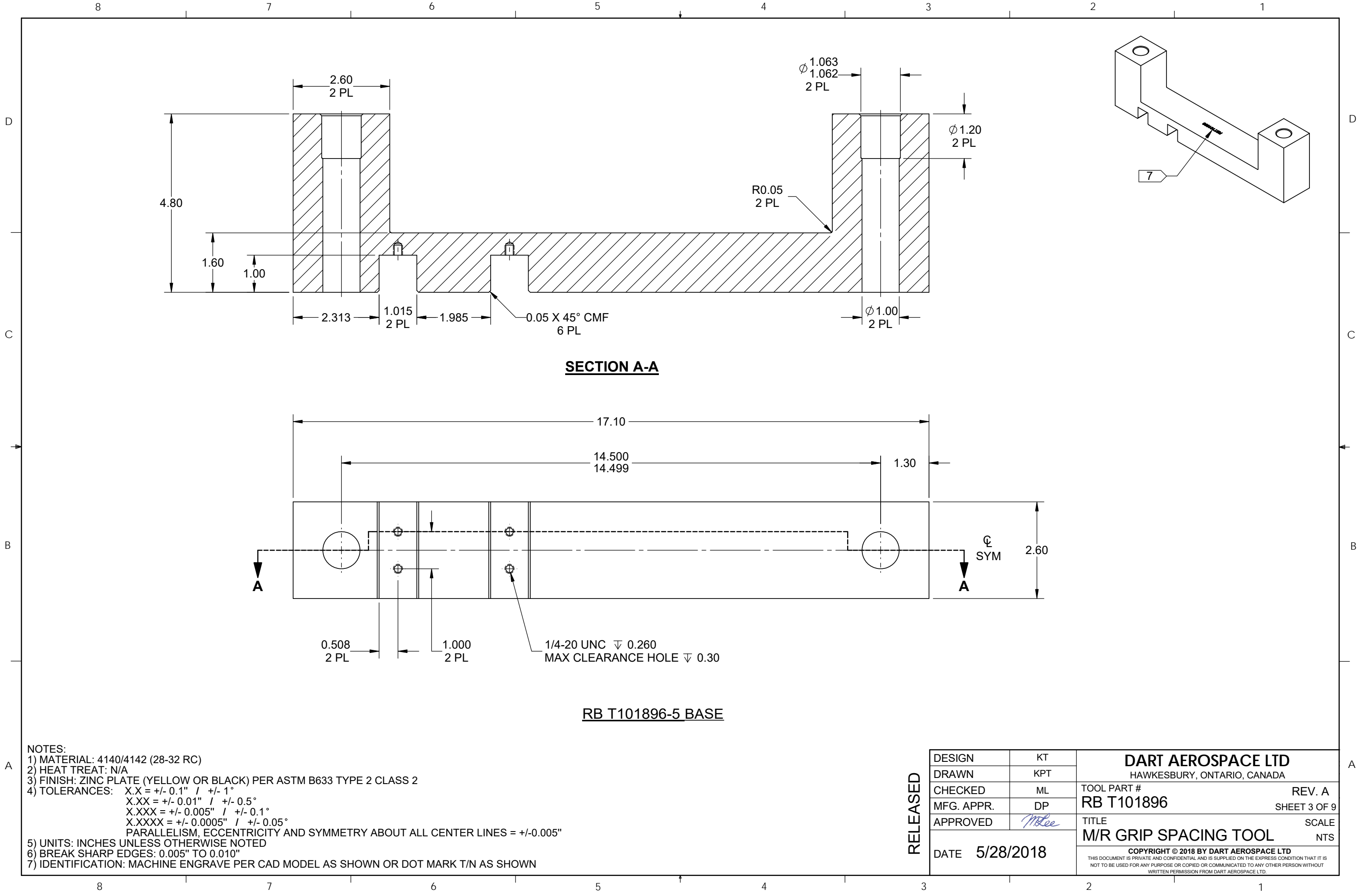
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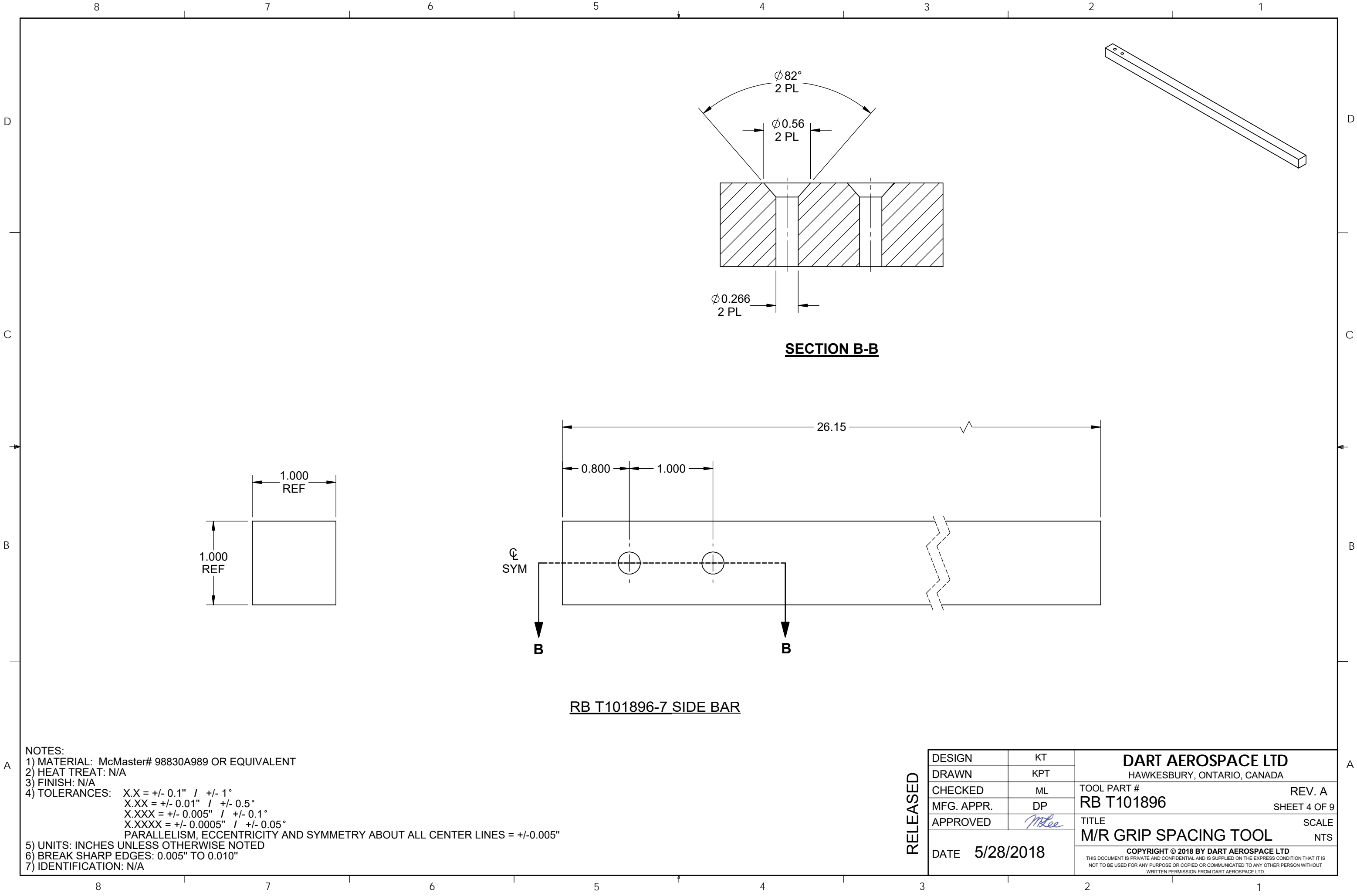
B

A

RELEASED

A	NEW ISSUE	18-727	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101896	SHEET 1 OF 9
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 5/28/2018		M/R GRIP SPACING TOOL	NTS
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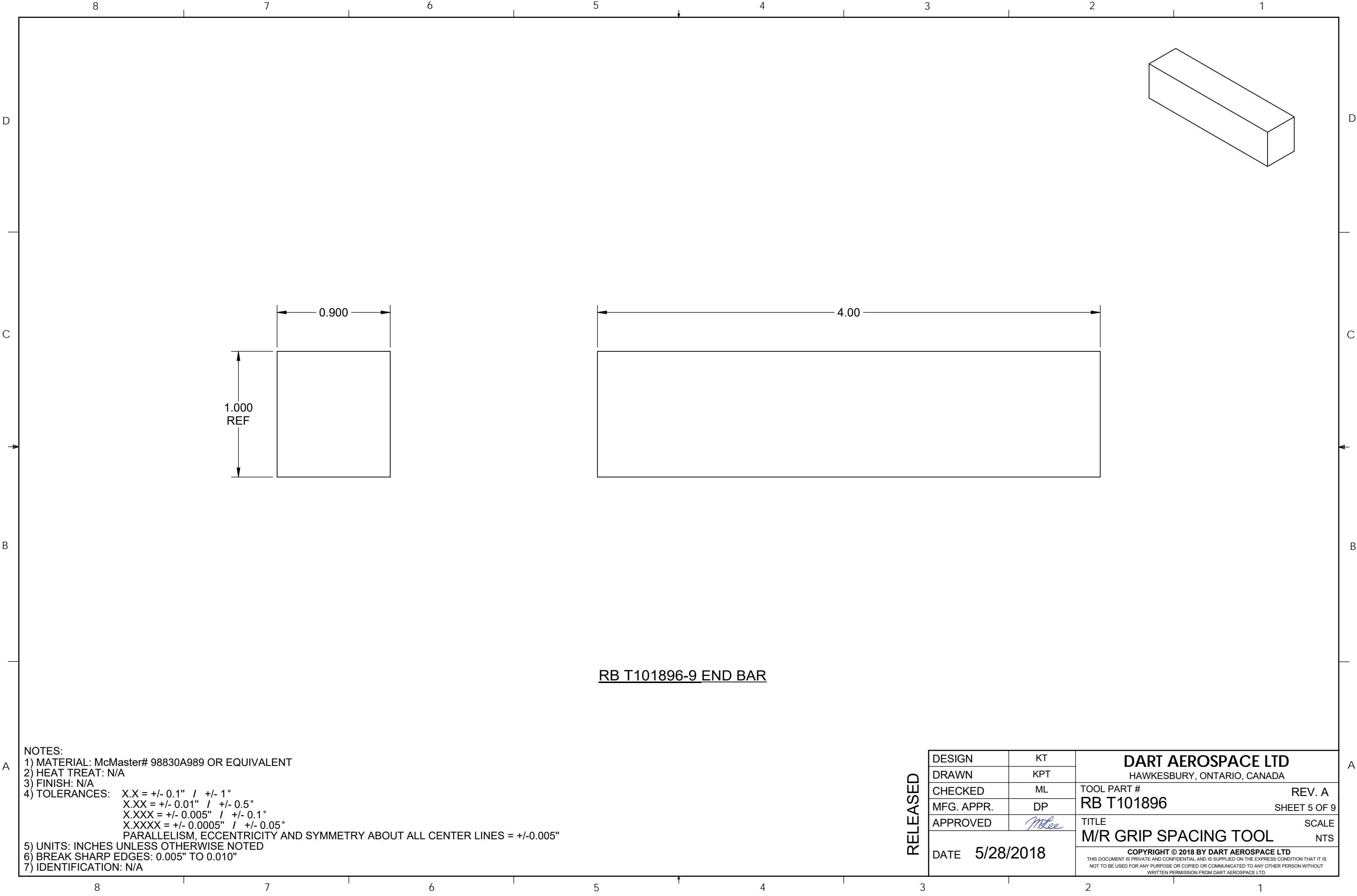




NOTES:
1) MATERIAL: McMaster# 98830A989 OR EQUIVALENT
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
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6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

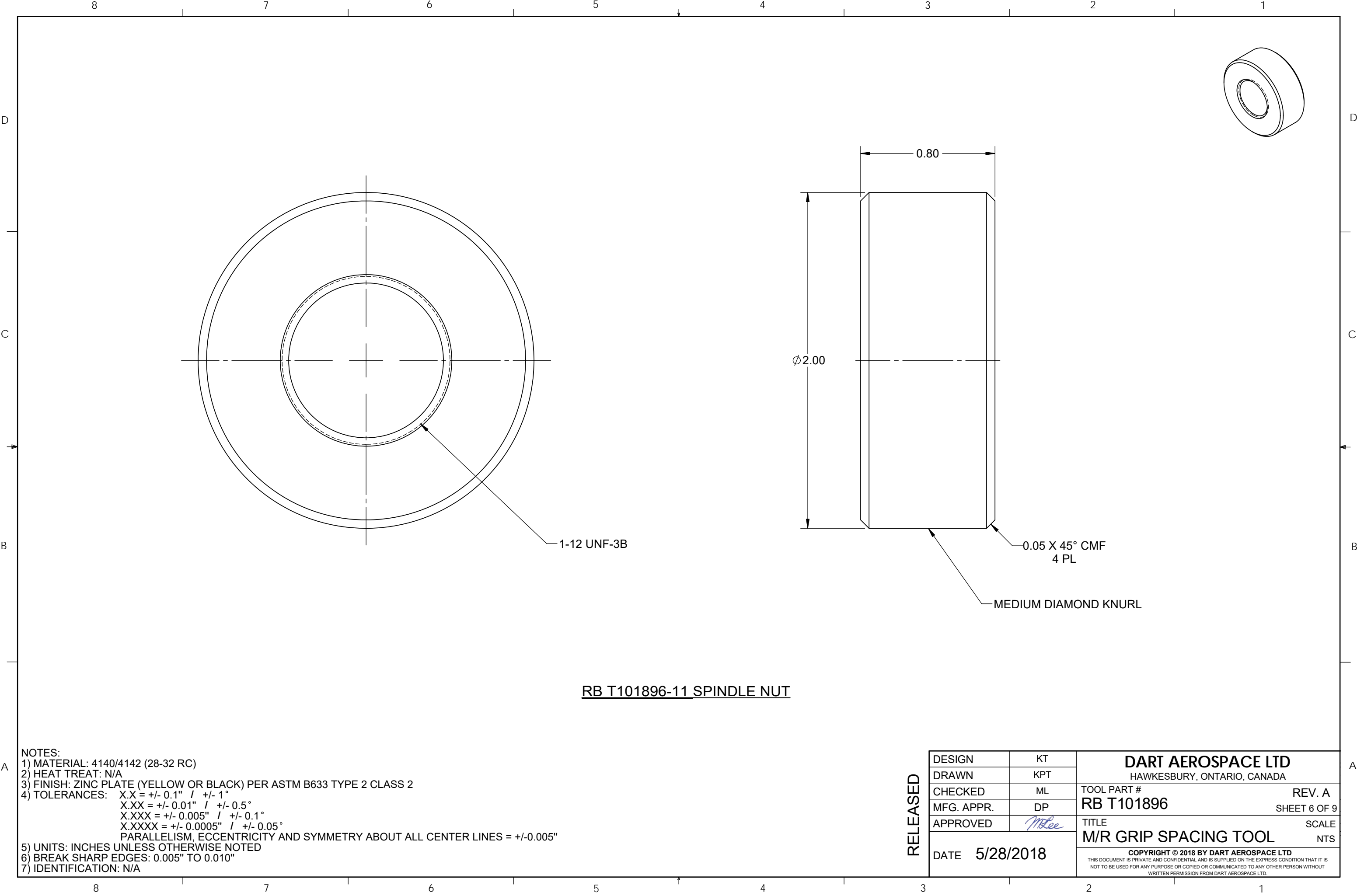
RELEASED

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101896	SHEET 4 OF 9
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 5/28/2018		M/R GRIP SPACING TOOL	NTS
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	CHECKED	ML	TOOL PART #	REV. A
	MFG. APPR.	DP	RB T101896	SHEET 5 OF 9
	APPROVED	<i>M. Lee</i>	TITLE	SCALE
	DATE 5/28/2018		M/R GRIP SPACING TOOL	NTS
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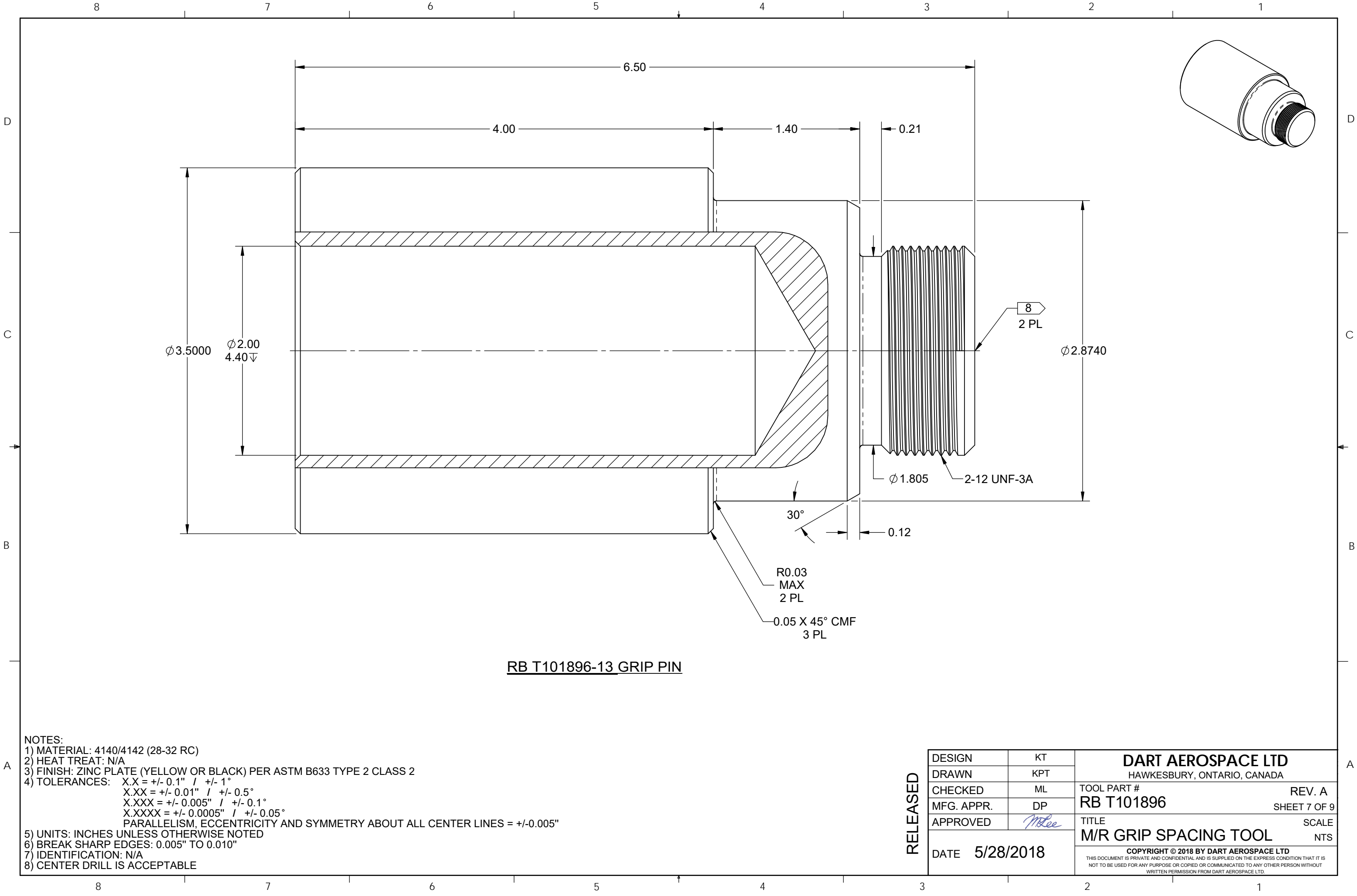


NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
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RB T101896-11 SPINDLE NUT

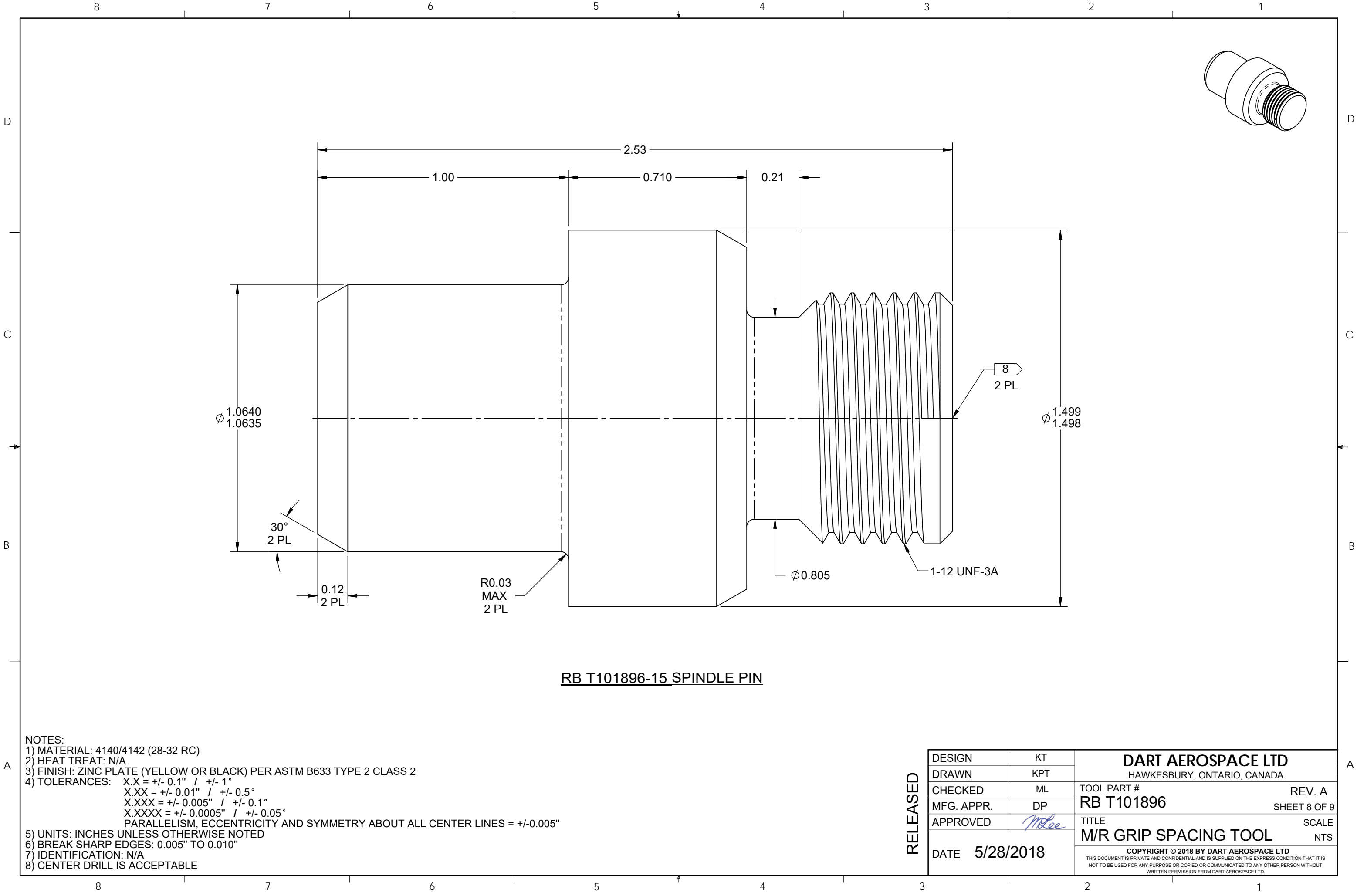
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DRAWN	KPT		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101896	SHEET 6 OF 9
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 5/28/2018		M/R GRIP SPACING TOOL	NTS
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7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

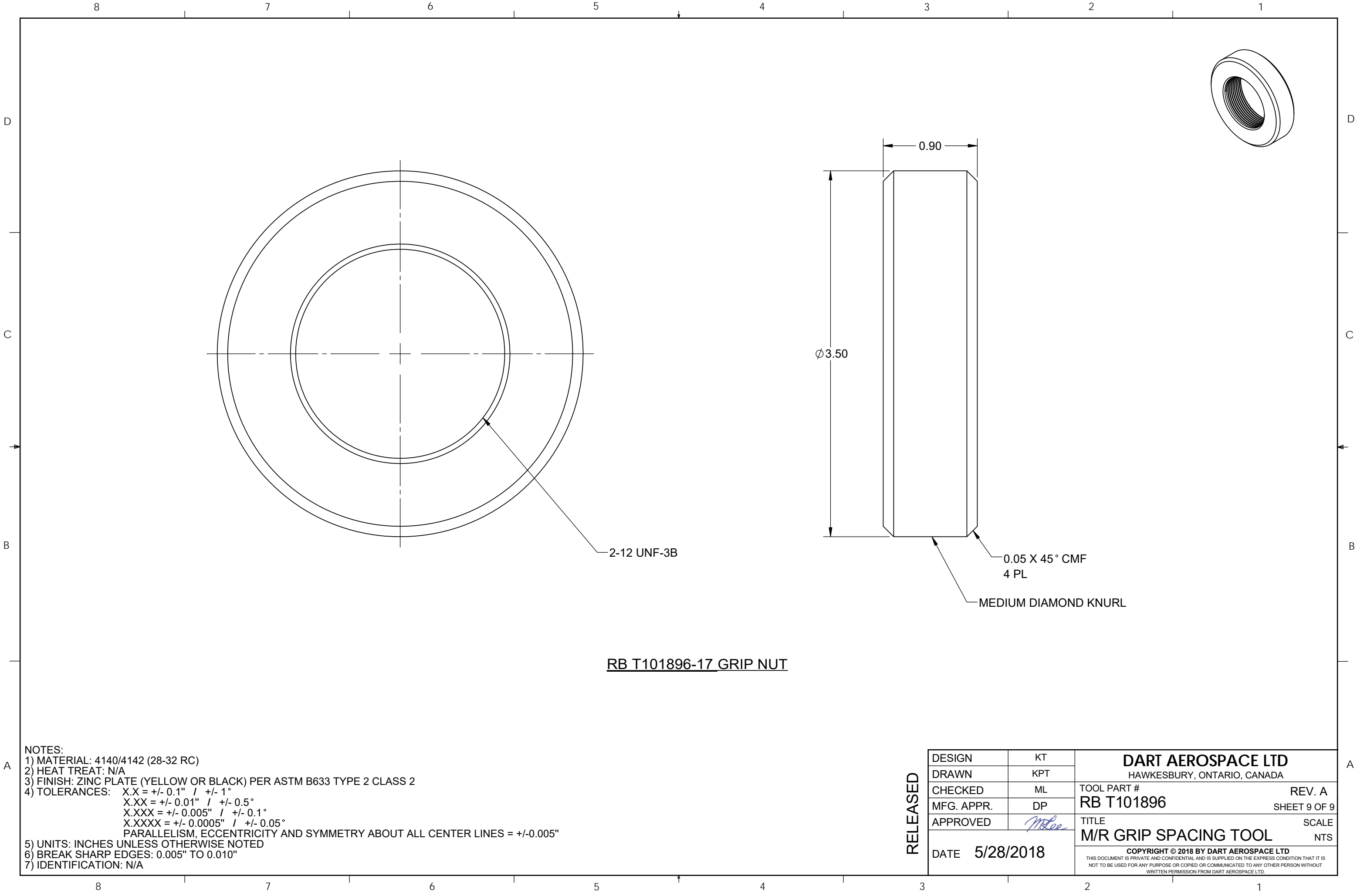
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	DRAWN	KPT		
	CHECKED	ML	TOOL PART #	REV. A
	MFG. APPR.	DP	RB T101896	SHEET 7 OF 9
	APPROVED	<i>M. Lee</i>	TITLE	SCALE
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DRAWN	KPT		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101896	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DATE 5/28/2018		M/R GRIP SPACING TOOL	NTS
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	DRAWN	KPT		
	CHECKED	ML	TOOL PART #	REV. A
	MFG. APPR.	DP	RB T101896	SHEET 9 OF 9
	APPROVED	<i>MLee</i>	TITLE	SCALE
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